



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3552-11
Job Sheet 187213



Part No: D3552-11

Job Qty: 12 ea

Part Name: Door Prop



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3552 Rev M IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C as per dwg RevE DD 10.02.17 verified by:EC IPP Rev:D 10.12.03 as per dwg rev.G DD verf:EC/ IPP Rev E 18.04.05 Rev M DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs	12/13/18	12/13/18	0.00	0.00	Purchasing		DEC 07 2018
110	Packaging	12 pcs	12/13/18	12/13/18	0.00	0.00	Packaging2		DEC 07 2018
120	QC	12 pcs	12/13/18	12/13/18	0.00	0.00	QC6		DAS 61
130	Packaging	12 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-1		9-89
140	QC21-SA	12 Ea	12/13/18	12/13/18	0.00	0.00	QC21		9-89

Part Op 100 - Issue P/O: 041889 Purchase Part Number: B8-240-575-150N Supplier: LS Technologies Certificate of
Descriptions: conformity is required
110 - Ensure certificate of conformity is attached
120 - Test for correct pressure

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
B8-240-575-150N	Gas Spring D3552-11	12 pcs (1 ea)	100-Purchasing	5135810

CTx12

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	B8-240-575-150N	12	0	0

Part Specifications

Specifications could not be found.

Plex 11/29/18 8:05 AM Dart.lajeunesse.marie



Container No: S135811



Part: D3552-11

Job No: 187213

Serial No/Batch: S135811

Revision: M

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/07/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



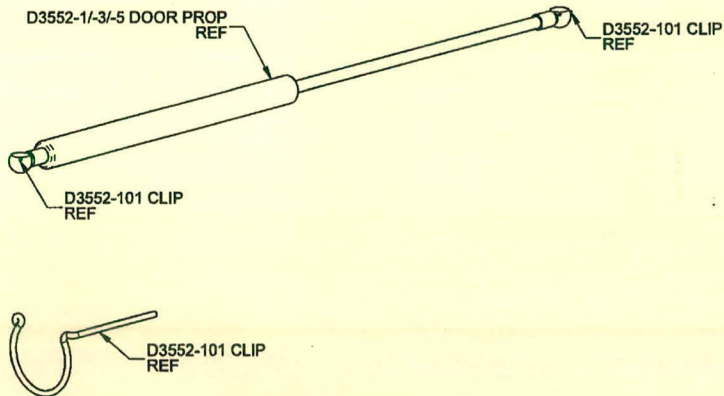
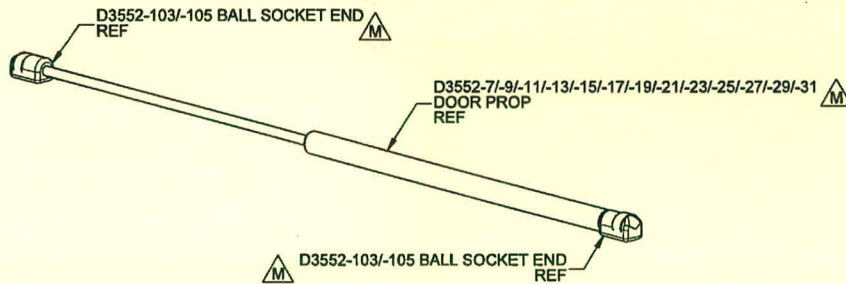
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1811-29

M	ADD P/N D3552-31, REF CIR18-114, UPDATED P/N D3552-101/-103, ADDED P/N D3552-105, REVISED NOTE 3, ADDED NOTE 4	WK	18.03.20
L	ADD P/N D3552-29	VS	15.04.13
K	ADD "X" TO LS TECHNOLOGIES P/Ns TO DESIGNATE "EXTRA DAMPING" FOR D3552-15/-17/-19/-25/-27. REASON: PAR12-209.	MB	12.07.16
J	ADD P/N D3552-25/-27. REMOVE ALTERNATE PART NUMBER FOR -15, -17 AND -18. STROKE FOR -15, -17 AND -19 WAS 139/5.06 NOW 154/6.06, EXTENDED LENGTH FOR -15, -17 AND -19 WAS 388/15.2 NOW 387/15.2.	AP	11.12.07
I	ADD P/N D3552-23	RF	11.10.11
H	ADD P/N D3552-21	DC	11.03.10
G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 388/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO. D3552	REV. M
MFG. APPR.	RA	SHEET 1 OF 2	
APPROVED	HS	TITLE DOOR PROP	SCALE NTS
DE APPR.	DS	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.03.20		

RELEASED

2018 APR 02
ECN 16-695



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156NX
D3552-19	DOOR PROP W/EXTRA DAMPING	154/6.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-410-070N
D3552-23	DOOR PROP	190/7.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.83	475/18.7	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-156NX
D3552-29	DOOR PROP	190/7.48	475/18.7	100/22.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-100N
D3552-31	DOOR PROP	190/7.48	475/18.7	147/33.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-190-475-147N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9-8
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B6
D3552-105	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B8

D3552-X DOOR PROP

RELEASED

2018 APR 02

NOTES:

- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS COMPATIBLE WITH D3552-13/-21/-23/-29/-31 DOOR PROPS
- 4) D3552-105 BALL SOCKET END IS COMPATIBLE WITH D3552-7/-9/-11/-15/-17/-19/-25/-27 DOOR PROPS

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	RF	DRAWING NO. D3552	REV. M
MFG. APPR.	RA		SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP	NTS
DATE	18.03.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



E-MAIL D

Plex 11/29/18 11:05 AM dart.tsimiklis.chrisoula

Packing Slip

LS TECHNOLOGIES INC

1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
041889	11/30/2018	19434

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship

Via

Fed-Ex

Qty	Description
12	D3552-11 # 187213 Gas Spring
Shipping Via FED EX Ground Tracking # 773850807913	
DAS 61 9-89	

Order checked by :





LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Nov 30, 2018

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: D3552-11 #187213 Gas Spring

DAS
61
9-89

Country of Manufacture: Canada
Date of Manufacture : Nov 2018
This product is ROHS compliant.

Purchase Order # 041889
Invoice # 19434

L S Technologies Inc Canada

A handwritten signature in blue ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President

